

# Work Order ID 73541

Friday, September 02, 2011 8:52:47 AM



Page 1

Item ID: D3016-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset

Start Date: 9/2/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3016

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3016  
Deburr if necessary

Dwg Rev: *A*

Prog Rev: *A* 2-

4134 - 049

B11-9-21

(9)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-9-21

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8 11/09/21

(+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73541

Friday, September 02, 2011 8:52:47 AM



Page 2

Item ID: D3016-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset

Start Date: 9/2/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and bag with light oil (Vactra oil #2), then Stock \*\*\*\*\*STOCK IN  
LARGE FAB\*\*\*\*\*  
Location WA

11/9/21

SP (90)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/9/21

MF 11-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, September 02, 2011 8:52:44 AM

Page 1

Work Order ID: 73541

Parent Item: D3016-15

Parent Item Name: Gusset



Start Date: 9/2/2011

Required Date: 9/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B..03.05.09 Reformat KJ/RF ;  
IPP Rev:C 08-04-11 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M4130NS.049

Purchased

No

100

sf

8.4000

0.0486

0.204632



4130 Sheet .049

Location

Loc Qty

Loc Code

MAT020

8.4

11612

8.4

11612

5  
HB11-9-21

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	73541
<b>Description:</b> Gusset		<b>Part Number:</b>	D3016-15
<b>Inspection Dwg:</b> D3016 <b>Rev:</b> A			<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <u>RB</u>	Audited by: <u>S</u>	Preliminary Approval:
Date: <u>11-9-21</u>	Date: <u>11/08/21</u>	Date:

Rev	Date	Change	Revised by	Approved
A	11.04.28	New Issue	KJ	[Signature]



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

#### NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

*W073541*

DEO ATTACHED

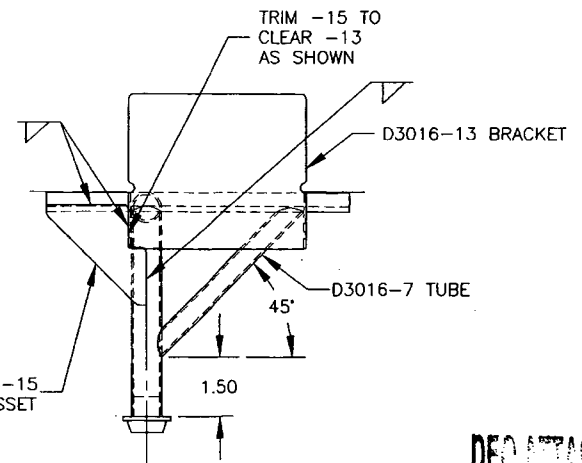
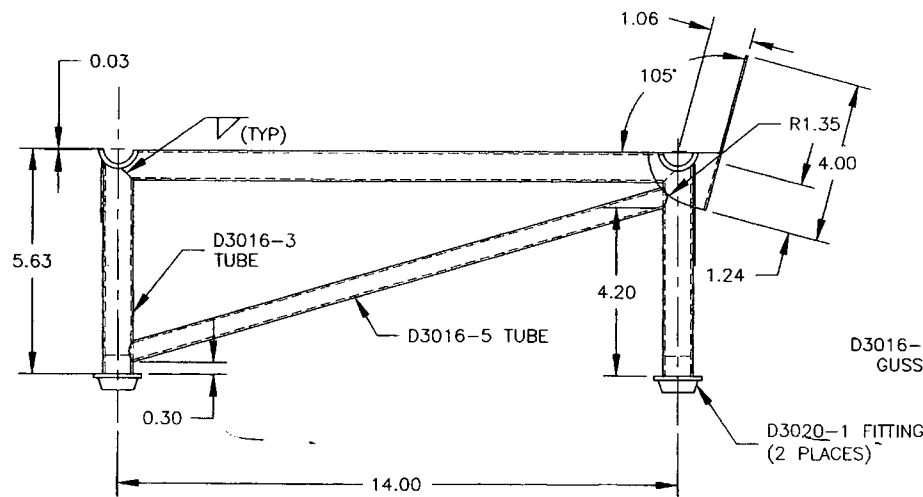
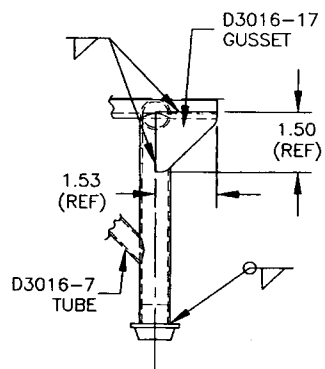
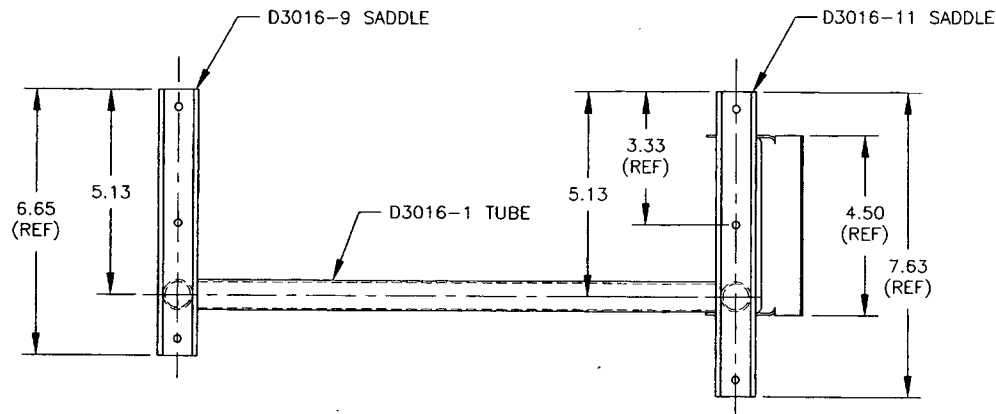
RELEASED  
01.05.30 *#*

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# D3016-041 SEAT FRAME ASSEMBLY



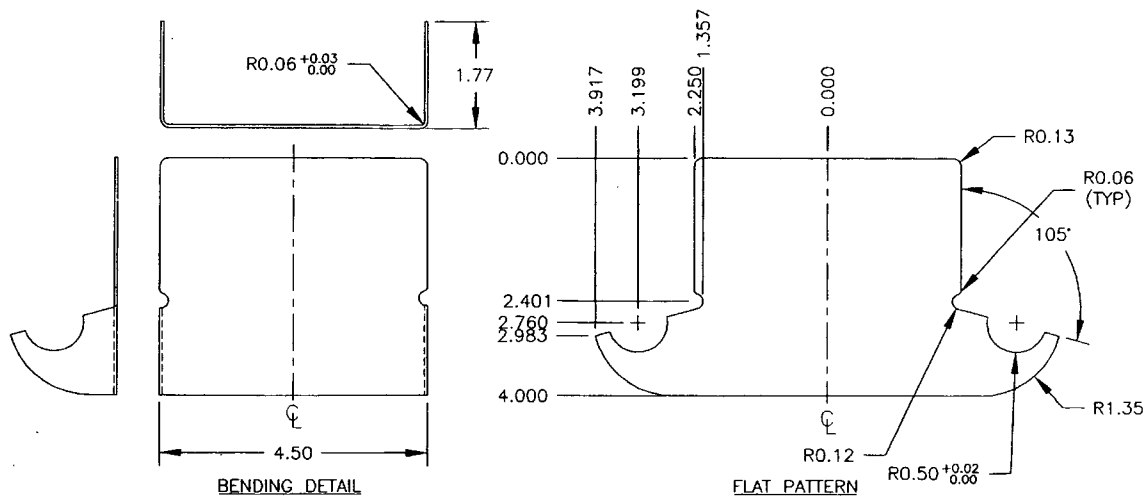
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01.05.30

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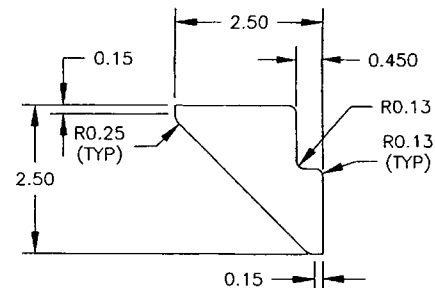
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DESIGN	CP	DRAWN BY	CP	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3016	REV. A
DATE	01.05.18	TITLE	SEAT FRAME ASSEMBLY	SHEET 2 OF 3	SCALE 1:3

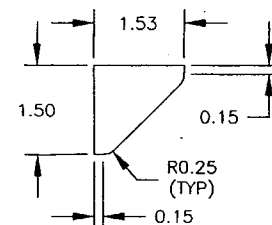
73541



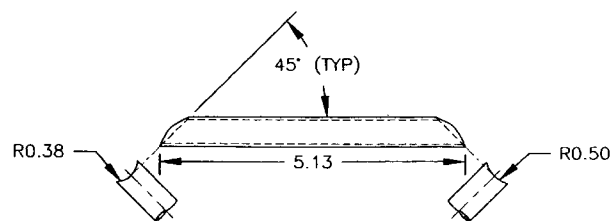
D3016-13 BRACKET



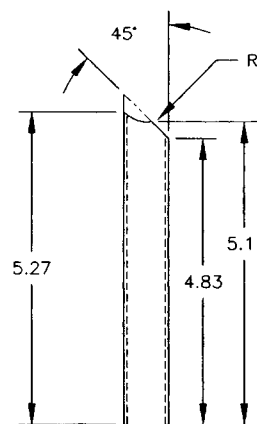
D3016-15 GUSSET



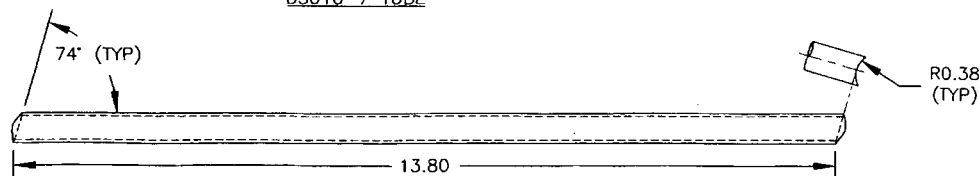
D3016-17 GUSSET



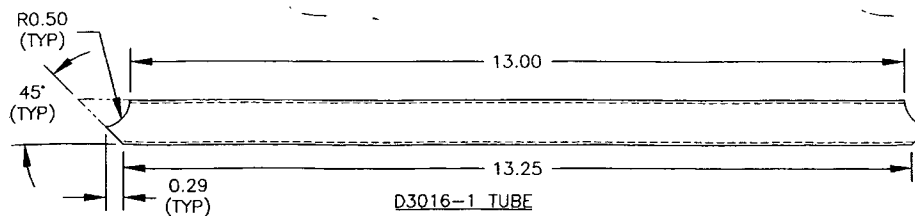
D3016-7 TUBE



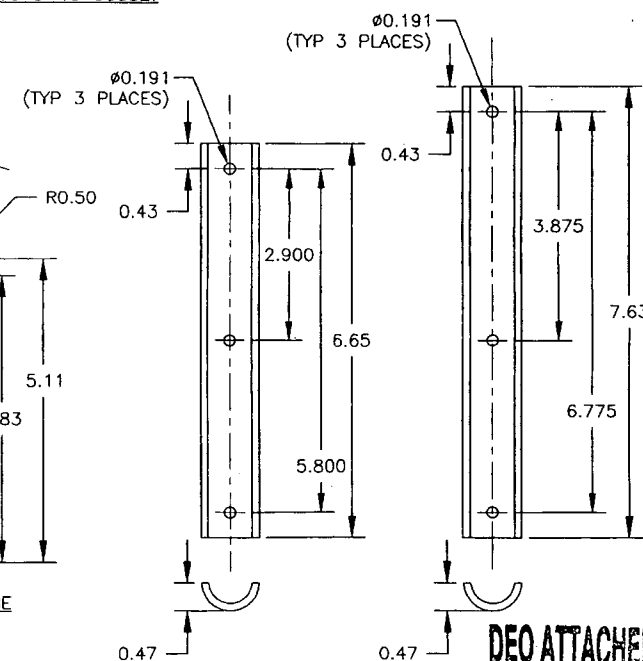
D3016-3 TUBE



D3016-5 TUBE



D3016-1 TUBE



D3016-9 SADDLE

DEO ATTACHED  
RELEASED  
9.05.30

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DESIGN	CP	DRAWN BY	CP	<b>DART</b>	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3016	REV. A
DATE	01.05.18	TITLE	SEAT FRAME ASSEMBLY	SHEET 3 OF 3	SCALE 1:2

DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 1	CHECKED UP	MFG. APPR. RE	APPROVED MP	DE APPR. H		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	

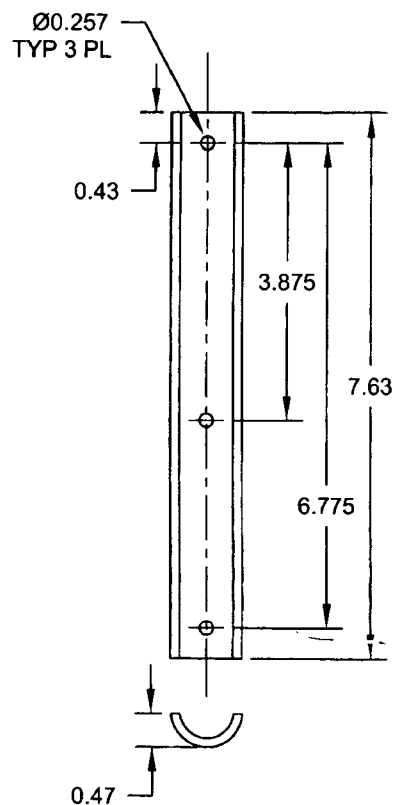
**PURPOSE:**

TO REVISE D3016-11 SADDLE'S HOLE SIZES

**CHANGE:**

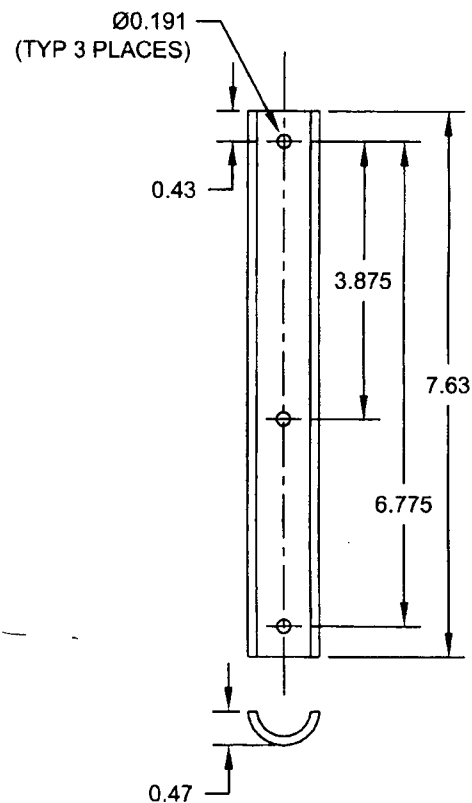
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

**IS:**



**D3016-11 SADDLE**

**WAS:**



**D3016-11 SADDLE**